

Ref. 750

Work Order ID 117198

April-24-14 10:08:08 AM

117198

Page 1

Item ID: D3532-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 4/23/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-04-29

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3532	Rev A

100 0.00

DAS

100

Hardinge CNC LATHE SMALL

44

9-89

14/05/28

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

1-TURN AS PER FOLIO FA643 & DWG D3532 ,FOLIO
REV: A DWG REV: A 2-DEBURR AS REQUIRED

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

44

9-89

14/05/28

110

QC

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

DAS

40

9-89

14/05/28

120

QC

Quality Control

Memo

0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS										
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering								
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other								
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear <ul style="list-style-type: none"> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube 				General		<ul style="list-style-type: none"> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence 									
				General											
				<input type="checkbox"/> Bend						<input type="checkbox"/> Folio/Program		<input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Pressure/Forced	
				<input type="checkbox"/> BOM/Route						<input type="checkbox"/> Grain		<input type="checkbox"/> Over/Under tolerance		<input type="checkbox"/> Set-up	
				<input type="checkbox"/> Broken/Damage/Defect						<input type="checkbox"/> Hardware		<input type="checkbox"/> Part Incorrect		<input type="checkbox"/> Temperature/Cure	
				<input type="checkbox"/> Burrs						<input type="checkbox"/> Inspection Incomplete/Unqualified		<input type="checkbox"/> Part Lost/Missing		<input type="checkbox"/> Weld	
				<input type="checkbox"/> Contamination						<input type="checkbox"/> Instructions Incomplete/Unclear		<input type="checkbox"/> Part Moved		<input type="checkbox"/> Wrong Stock Pulled	
				<input type="checkbox"/> Countersink						<input type="checkbox"/> Misaligned/off center		<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Power Loss/Surge	
				<input type="checkbox"/> Cut Too Short						<input type="checkbox"/> Mislabeled		<input type="checkbox"/> Other		<input type="checkbox"/>	
				<input type="checkbox"/> Drawing						<input type="checkbox"/> Misread		<input type="checkbox"/>		<input type="checkbox"/>	
				<input type="checkbox"/> Drill Holes						<input type="checkbox"/> Off-set		<input type="checkbox"/>		<input type="checkbox"/>	
				<input type="checkbox"/> Finish						<input type="checkbox"/> Out of Calibration		<input type="checkbox"/>		<input type="checkbox"/>	
				<input type="checkbox"/> Fit/Function						<input type="checkbox"/> Out of Sequence		<input type="checkbox"/>		<input type="checkbox"/>	

Work Order ID 117198

April-24-14 10:08:08 AM

117198

Page 2

Item ID: D3532-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 4/23/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 81054 0.00

130

Packaging

Packaging

Memo

0.00

20 14-5-29
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

14/5/30 14

14-5-29

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite
Part No. _____		<input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier
NCR No. _____		<input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

April-24-14 10:08:10 AM

Page 1

Work Order ID: 117198

117198

Parent Item: D3532-1

D3532-1

Parent Item Name: Spacer

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-07-12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No			f		32.0997		1			**

MDFI RINR0 750

Delrin Round Bar 0.75" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	32.0997	
m127442	32.0997	

M129148

→ 1'

DAS
44
9-89 14/05/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced							
	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up							
	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure							
	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld							
	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled							
	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong								
	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge								
	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread									
	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set									
	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration									
	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence									

DART AEROSPACE LTD	Work Order:	117198
Description: Spacer	Part Number:	D3532-1
Inspection Dwg: D3532	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

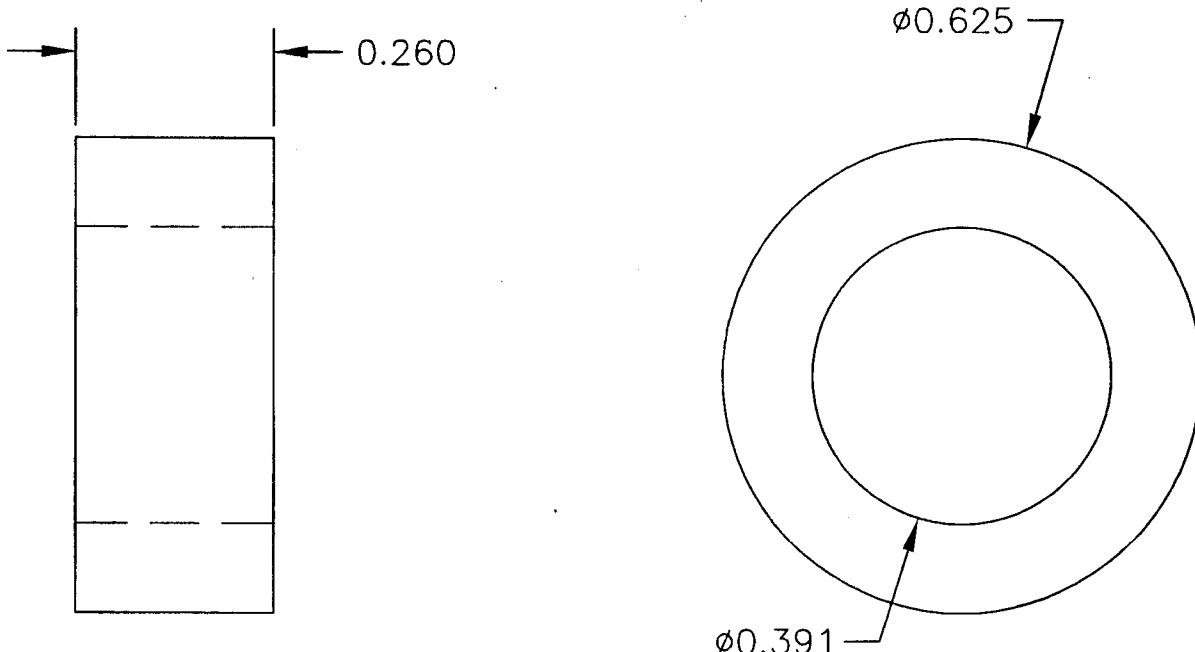
DAS

Measured by:	44 9-89	Audited by:	40 9-89	Prototype Approval:	N/A
Date:	14/05/28	Date:	14/05/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.09	New Issue	KJ/EC/DD	Z

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3532
DATE 06.06.26		TITLE SPACER
A	06.06.26	SCALE 4:1 NEW ISSUE

**D3532-1 SPACER****D3532-1 SPACER**

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

62-K014
2007-06-26

RELEASED
06-06-26

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